

Date: Tuesday, 10/2/2007 10:44:01 AM  
 User: Kim Johnston

## Process Sheet

44

|                       |                                       |          |                  |                  |               |  |  |
|-----------------------|---------------------------------------|----------|------------------|------------------|---------------|--|--|
| Customer              | : CU-DAR001 Dart Helicopters Services |          |                  | Drawing Name     | : WEARPAD     |  |  |
| Job Number            | : 34943                               |          |                  | Part Number      | : D35371      |  |  |
| Estimate Number       | : 12712                               |          |                  | Drawing Number   | : D3537 REV C |  |  |
| P.O. Number           | :                                     |          |                  | Project Number   | : N/A         |  |  |
| This Issue            | : 10/2/2007                           | S.O. No. | :                | Drawing Revision | : C           |  |  |
| Prsh Rev.             | : NC                                  |          |                  | Material         | :             |  |  |
| First Issue           | : / /                                 | Type     | : SMALL /MED FAB | Due Date         | : 10/30/2007  |  |  |
| Previous Run          | : 34282                               |          |                  | Qty:             | 125           |  |  |
| Written By            | : <u>JL</u> 07-10-02                  |          |                  | Um:              | 100 Each      |  |  |
| Checked & Approved By |                                       |          |                  |                  |               |  |  |
| Comment               | : Est Rev A New Issue 07-02-14 JLM    |          |                  |                  |               |  |  |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :  |
|---------|-----------------------|--|
| 1.0     | M304S16GA             | 304/316 .063 Sheet<br><br>10.0076  |
|         |                       |  |
|         |                       | Comment: Qty.: 0.0788 sf(s)/Unit Total : 7.8750 sf(s)<br>M304S16GA .063" 304 SS SHEET<br>Batch: <u>10S 130</u> <u>1B 07-10-9</u> |
| 2.0     | WATER JET             | FLOW WATER JET   |
|         |                       |  |
|         |                       | Comment: FLOW WATER JET<br>1-Cut as per Dwg D3537<br>Dwg Rev: <u>C</u> <u>1B 07-10-9</u><br>Prog Rev: <u>C</u>                   |
|         |                       |  |
|         |                       | 2-Deburr if necessary <u>1B 07-10-9</u>  |
| 3.0     | QC2                   | INSPECT PARTS AS THEY COME OFF MACHINE<br><br><u>1B 07-10-9</u>  |
|         |                       |  |
|         |                       | Comment: INSPECT PARTS AS THEY COME OFF MACHINE  |
| 4.0     | QC8                   | SECOND CHECK   |
|         |                       |  |
|         |                       | Comment: SECOND CHECK<br><u>Er 02/10/10 X/125</u>  |
| 5.0     | BRAKE NC              | NC BRAKE   |
|         |                       |  |
|         |                       | Comment: NC BRAKE<br>1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.<br>2-Identify as D3537-1               |
|         |                       | <u>SP 07/10/11</u> <u>(125)</u>  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 10:44:01 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 34943

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch  
A/R 2059B Hardcoat M105599/M106036

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

FC/88

07/10/26

125x

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-29 125

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

G 07/10/29 \*125

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 105642

125

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-p 07/10/31

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP17

BR

07-10-31

125 07.10.31

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07.10.31

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                       |              |             |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD    | Work Order:  | 349A3       |
| Description: Wearpad  | Part Number: | D3537-1     |
| Inspection Dwg: D3537 | Rev: C       | Page 1 of 1 |

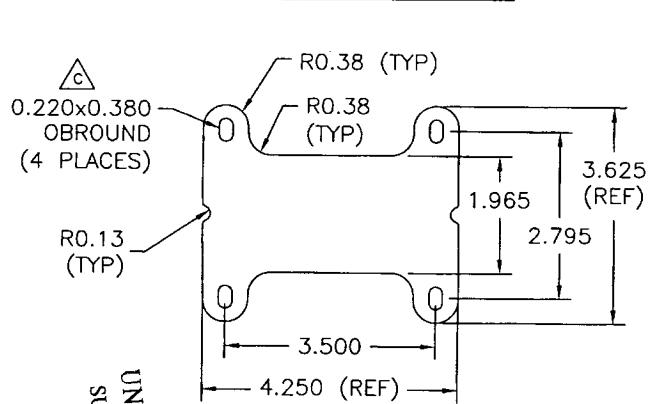
# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

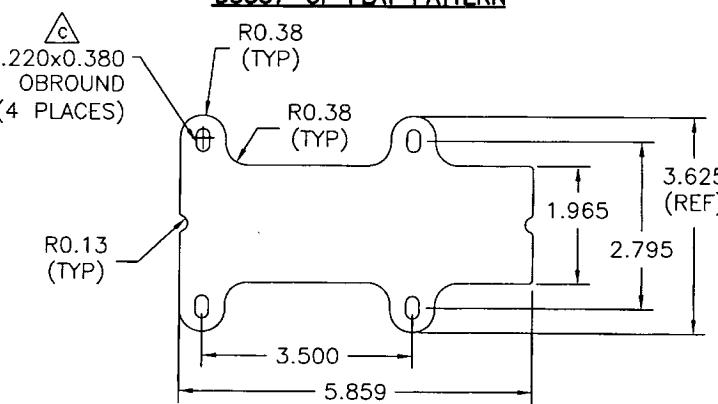
|              |           |             |           |                     |     |
|--------------|-----------|-------------|-----------|---------------------|-----|
| Measured by: | <u>VB</u> | Audited by: | <u>CR</u> | Prototype Approval: | N/A |
| Date:        | 07-10-9   | Date:       | 07/10/17  | Date:               | N/A |

| Rev | Date     | Change                            | Revised by | Approved           |
|-----|----------|-----------------------------------|------------|--------------------|
| A   | 07.03.21 | New Issue                         | KJ/JLM     |                    |
| B   | 07.04.27 | Dimensions revised per Dwg Rev. B | KJ/JLM     |                    |
| C   | 07.05.28 | Dimensions revised per Dwg Rev. C | KJ/JLM     | <i>[Signature]</i> |

### D3537-1F FLAT PATTERN

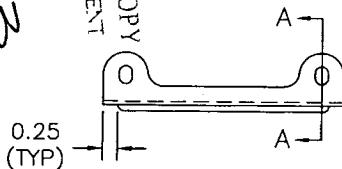


### D3537-3F FLAT PATTERN

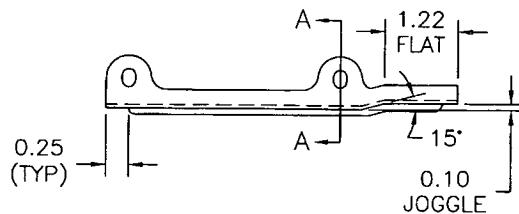


NO. 349143  
SUBJECT TO ANNOTATION  
WITHOUT ANNOTATION  
WORK ORDER NO. 111-143  
ENGINEERED COPY  
MADE FROM D3537-1F

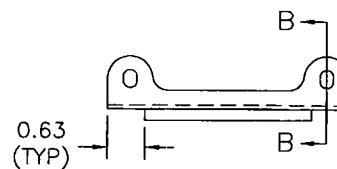
SHOP COPY  
RETURN TO  
ENGINEER  
COPY  
MADE FROM D3537-1F



### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

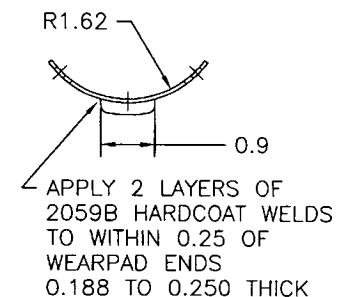


### D3537-1/-3/-5/-7 WEARPAD NOTES

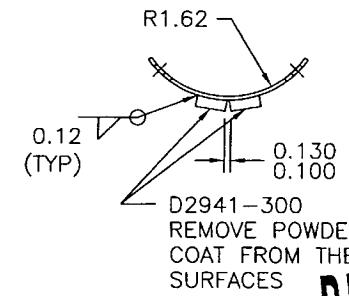
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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### SECTION A-A

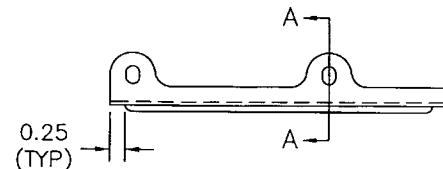


### SECTION B-B



RELEASED  
07.05.08 A#  
per ECN  
962

### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



|          |          |  |
|----------|----------|--|
| C        | 07.04.13 | WIDEN TAB TO 0.380, WELD PATTERN             |
| B        | 07.03.20 | ADD AMS 5513 AND AMS 5524                    |
| A        | 06.11.06 | NEW ISSUE                                    |
| DESIGN   | DRAWN BY | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |
| CB       | PH       |  |
| CHECKED  | APPROVED | DRAWING NO.<br>D3537                         |
| DATE     | TITLE    | REV. C<br>SCALE<br>1:2                       |
| 07.04.13 | WEARPAD  |  |